Work Order ID 73419

Wednesday, August 31, 2011 3:16:02 PM

Item ID: D3502-1 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Support

Start Date: 8/31/2011 **Start Qty:** 20.00 **Cust Item ID:**

Required Date: 9/16/2011 **Req'd Qty:** 20.00 **Customer:**

Reference:

Approvals: **Process Plan:** CL **Date:** 11/09/01 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Draw Nbr	Revision Nbr
D3502	Rev B

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	BAND SAW	0.00			RQ 11.9.20	20	ϕ		
Bandsaw	**Memo**	0.00							
Jeaspa Bandsaw	Cut blank 3.475 " long□1 BLANK MAKES 2 PARTS								
110	HAAS CNC VERTICAL MACHINING #1	0.00			RQ 11.9.20	20	ϕ		
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	1- Mill as per Folio FA649 Rev: A/A & Dwg D3502 Rev: B □2-Deburr per dwg D3502								
120	QC2- Inspect parts off machine FAI/FAIB	0.00			RQ 11.9.20	20	ϕ		
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Run Start

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00				20	0		
QC	**Memo**	0.00	B.A 11/09/21						
Quality Control									
140		0.00				20	0		
Small Fab	Small Fab								
Small Fab	**Memo**	0.00							
	Mark hole position using DT9430□Drill as per Dwg D3502.								
150	Chemical Conversion Coat per QSI005 4.1	0.00				20	0	Mulcte	
HandFinish	**Memo**	0.00							
Hand Finishing									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Powdercoat Powder Coating M 118439	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				20X	Ø		M [signature] 11/09/21
	Memo START TIME: 3:30 FINISH TIME: 4:00 OVEN TEMPERATURE: 320°F	0.00							
170 QC Quality Control	QC3- Inspect Part Finish	0.00				20 counted	¢		[signature] 11/09/22
	Memo	0.00							
180 Packaging Packaging	Identify as per dwg & Stock Location: 63	0.00				11/9/22			[signature] (20)
	Memo	0.00							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

11/9/28

MF 11-09-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, August 31, 2011 3:16:00 PM

Work Order ID: 73419

Parent Item: D3502-1

Parent Item Name: Support

Start Date: 8/31/2011 **Required Date:** 9/16/2011

Start Qty: 20.00 **Required Qty:** 20.00

Comments: IPP Rev:A New Issue 06-07-06 JLM
IPP Rev:B Add tooling hole 07-03-28
Esr rev C added DT9430 08.11.03 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.000		Purchased	No			100	f	27.3670	0.289	6.084211			

6061-T6 Bar 1.00 x 4.00

11.9.20

Location	Loc Qty	Loc Code
MAT004	27.367	
114352	2.58	
116808	0.787	
118400	24	

2.58'

1.366'

not pulled

THIS BATCH # NOT IN THE SYSTEM MUST BE OLD. → 107221

1 BLANK MAKES 2 PARTS SO THIS JOB ONLY NEEDS 2.895' MIN.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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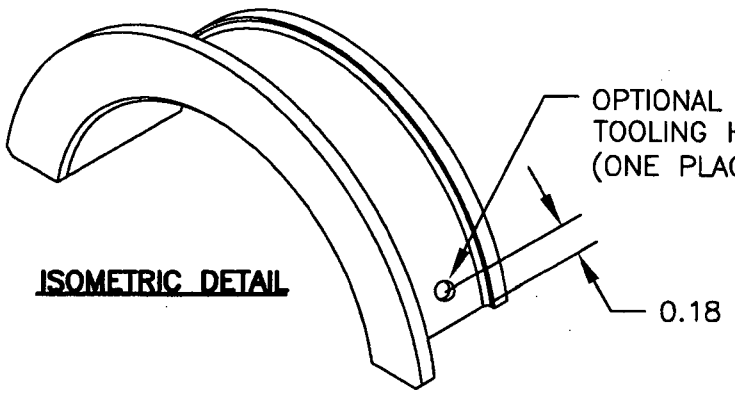
NOTE: Date & initial all entries

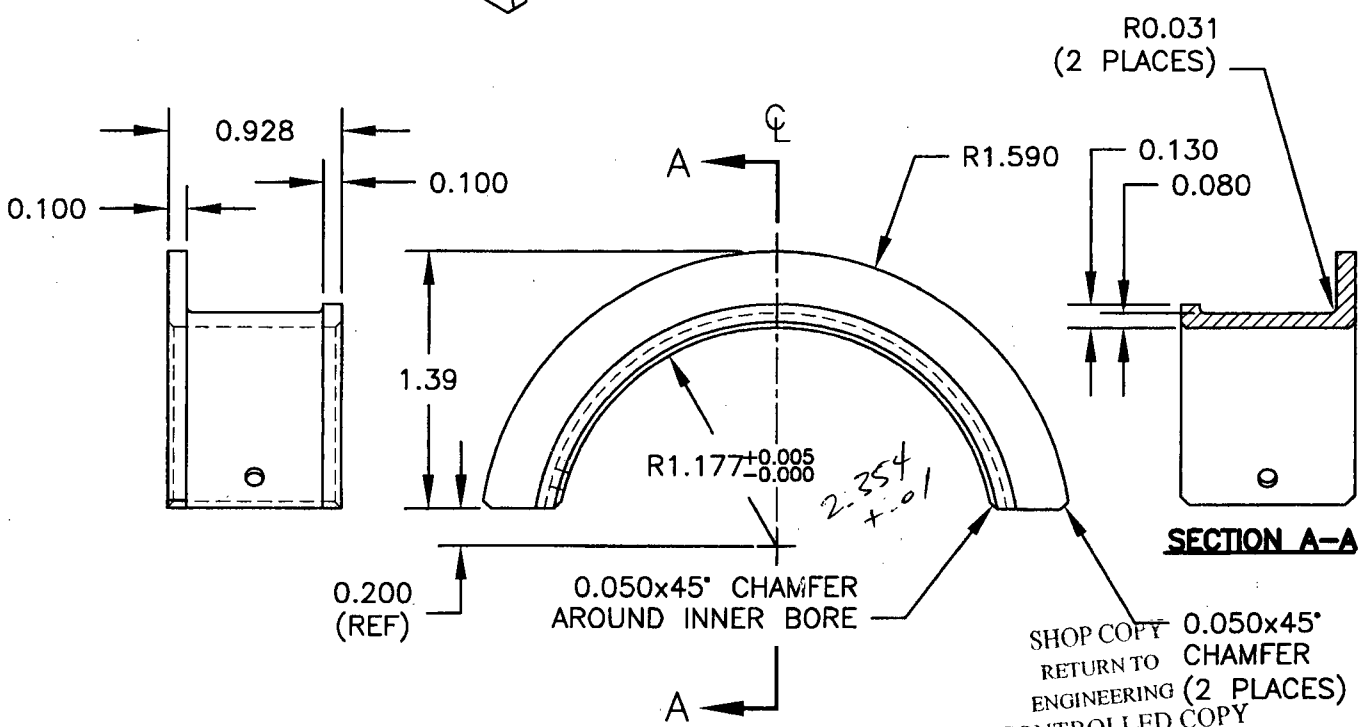
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3502	REV. B SHEET 1 OF 1
DATE 06.10.31		TITLE SUPPORT	SCALE 1:1

A	06.04.18	NEW ISSUE
B	06.10.31	ADD TOOLING HOLE FOR FINISHING



ISOMETRIC DETAIL

RELEASED
06.12.06
PER ECN 585



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 13419 CL 11090101

0.050x45° CHAMFER (2 PLACES)

D3502-1 SUPPORT

1) MATERIAL: 6061-T6 ROUND BAR (REF DART SPEC. M6061T6R)
2) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
3) PART IS SYMMETRIC ABOUT CENTERLINE
4) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ±0.010, X.XX = ±0.030) UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
   POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

DART AEROSPACE LTD	Work Order:	73419
Description: Support	Part Number:	D3502-1
Inspection Dwg: D3502 **Rev:** B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R1.590	+/-0.010	1.591	✓		DA 02	
R1.177	+0.005/-0.000	1.177	✓			
0.130	+/-0.010	.133	✓			
0.080	+/-0.010	.080	✓			
0.928	+/-0.010	.929	✓			
0.100	+/-0.010	.094	✓			
0.100	+/-0.010	.101	✓			
1.39	+/-0.030	1.395	✓			

Measured by:		Audited by:	D.A	Prototype Approval:	N/A
Date:	11.7.21	Date:	11/09/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue	KJ/JLM	
B	07.03.29	Dwg Rev. updated	KJ/JLM	